

Work Order ID 59605

Tuesday, June 08, 2010 3:04:46 PM



Page 1

Item ID: D4032-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Short Basket Assembly (350)

Start Date: 6/9/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/14/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: mf Date: 10-6-8

Tooling:

Date:

Run Start



QC: _____ Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4032	C

100	Pick Kit	0.00
-----	----------	------



Packaging

Memo

0.00

Packaging

110	Assemble as per dwg	0.00
-----	---------------------	------



HandFinish

Memo

0.00

Hand Finishing

120	QC5- Inspect part completeness to step on W/O	0.00
-----	---	------



QC

Memo

0.00

Quality Control

10/6/15 (1)

10/06/15 (2)

10/06/15

(4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 59605

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Comments: IPP RevA: new issue DD 09.12.02 verified by:EC
per PA3 DD 10.03.10 verified by:EC
10.03.23 verified by:EC
IPP Rev:B as
IPP Rev:C as per RevA DD
IPP Rev:D as per dwg revC DD 10.04.20
verified by:EC

Start Date: 6/9/2010

Required Date: 6/14/2010

Start Qty: 1.00

Required Qty: 1.00

D2530



Handle Weldment

Manufactured No

100

Each

1.0000

1

1



59184

Location

Loc Qty

Loc Code

ST506

1

58428

1

D2535



Spring

Manufactured No

100

Each

126.0000

2

2



56308

Location

Loc Qty

Loc Code

ST504

126

56355

26

58331

100

D2537



Bushing

Manufactured No

100

Each

33.0000

4

4



58429

Location

Loc Qty

Loc Code

ST504

33

58429

33

D3917-3



Washer

Manufactured No

100

Each

49.0000

6

6



58429

Location

Loc Qty

Loc Code

ST096

49

57144

1

58892

48

58892

W/O:		WORK ORDER CHANGES					
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IPP Rev:B as
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IPP Rev:D as per dwg revC DD 10.04.20
verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D3953-3	Manufactured	No	100	Each	13.0000	2	2		
Gas Spring Stud, Lid									
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST102	13					
			58894	13					
D3953-7	Manufactured	No	100	Each	13.0000	2	2		
Spring Spacer									
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST103	13					
			58893	13					
D3953-9	Manufactured	No	100	Each	9.0000	2	2		
Gas Spring Washer									
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST101	9					
			53642	9					
D3953-17	Manufactured	No	100	Each	9.0000	2	2		
Gas Spring Spacer									
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST101	9					
			57143	1					
			58857	8					

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10.03.23 verified by:EC
verified by:EC
IPP Rev:B as
IPP Rev:C as per RevA DD
IPP Rev:D as per dwg revC DD 10.04.20

Start Qty: 1.00

Required Qty: 1.00

D3953-19 Manufactured No 100 Each 18.0000 1 1
 Gas Spring Bracket

Location	Loc Qty	Loc Code
ST101	4	
57607	4	
ST103	14	

57607

D3953-21 Manufactured No 100 Each 29.0000 1 1
 Gas Spring Bracket

Location	Loc Qty	Loc Code
ENG	5	
56407	5	
ST102	24	
57145	7	
59214	17	

57145

D3969-3 Manufactured No 100 Each 14.0000 1 1
 Spring (Basket Lid)

Location	Loc Qty	Loc Code
ST	14	
56386	2	
58986	12	

56386

D4017-041 Manufactured No 100 Each 0.0000 1 1
 Short Basket Base Assembly (350)

B59606(12)

6/8/06/15

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W/O:		WORK ORDER CHANGES					
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IPP Rev:C as per RevA DD
IPP Rev:D as per dwg revC DD 10.04.20

Start Qty: 1.00

Required Qty: 1.00

AN5-17A	Purchased	No	100	Each	161.0000	4	4		
Bolt									
									</

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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10.03.23 verified by:EC
verified by:EC
IPP Rev:B as
IPP Rev:C as per RevA DD
IPP Rev:D as per dwg revC DD 10.04.20

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased No

100 Each

3,364.000 6

6



Nut

Location

Loc Qty

Loc Code

ST300

3364

113537

18

113644

5

114523

841

114718

500

114784

2000

114523

MS21042L5

Purchased No

100 Each

768.0000 4

4



Nut

Location

Loc Qty

Loc Code

ST139

500

114813

500

ST300

268

114449

268

114449

MS24665-151

Purchased No

100 Each

656.0000 3

3



Cotter Pin

Location

Loc Qty

Loc Code

ST309

656

17566

656

17566

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verified by:EC
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IPP Rev:C as per RevA DD
IPP Rev:D as per dwg revC DD 10.04.20

Start Date: 6/9/2010

Required Date: 6/14/2010

Start Qty: 1.00

Required Qty: 1.00

MS24665-300

Purchased

No

100

Each

70.0000

2

2



Cotter Pin

Location

Loc Qty

Loc Code

ST309

70

105279

2

110123

68

NAS1149F0463P

Purchased

No

100

Each

165.0000

6



Washer

Location

Loc Qty

Loc Code

ST275

165

114223

65

114348

100

NAS1149C0432R

Purchased

No

100

Each

752.0000

2



Washer

Location

Loc Qty

Loc Code

ST297

752

114292

152

114742

600

NAS1149F0363P

Purchased

No

100

Each

181.0000

8



Washer

Location

Loc Qty

Loc Code

ST275

181

113254

81

114382

100

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Dart Aerospace Ltd

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10.03.23 verified by:EC
verified by:EC
IPP Rev:B as
IPP Rev:C as per RevA DD
IPP Rev:D as per dwg revC DD 10.04.20

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0563P

Purchased

No

100

Each

234.0000

4

4



Washer

10-6-15

Location

Loc Qty

Loc Code

ST275

34

108471

34

ST298

200

114576

200

108471

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

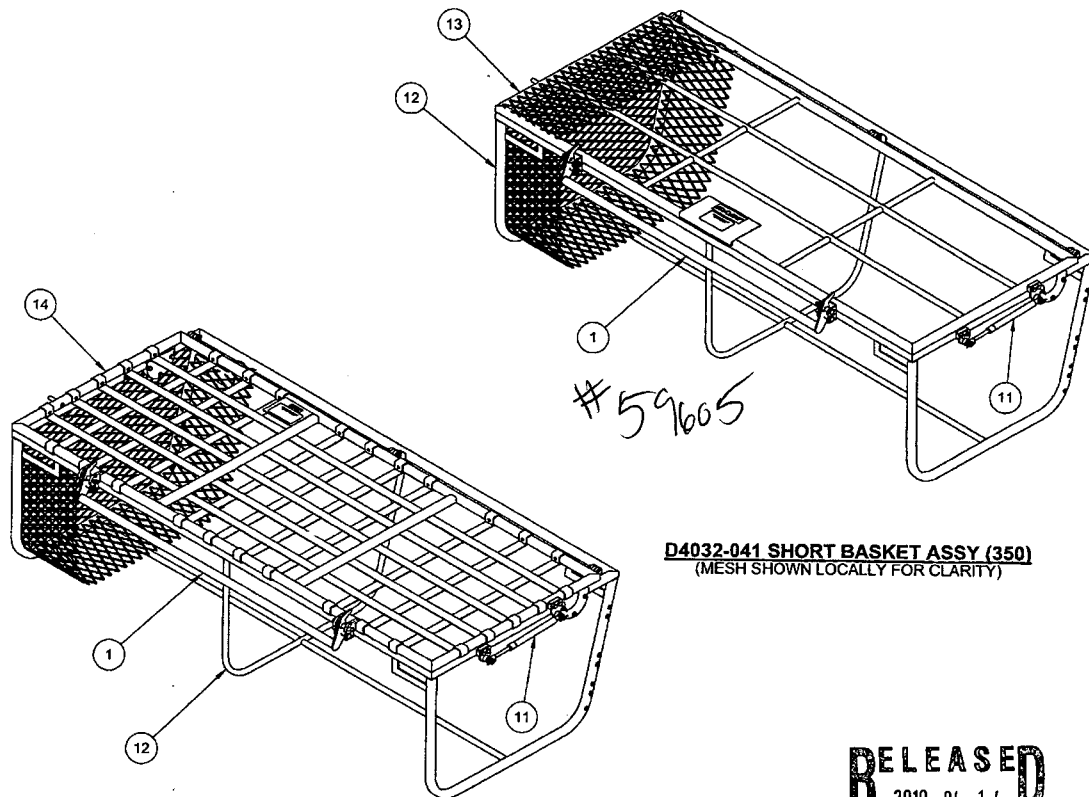
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

ITEM	-041 QTY.	-043 QTY.	P/N	DESCRIPTION
	X		D4032-041	SHORT BASKET ASSY (350)
		X	D4032-043	SHORT BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	4	4	D2537	BUSHING
4	6	6	D3917-3	WASHER
5	2	2	D3953-3	GAS SPRING STUD, LID
6	2	2	D3953-7	GAS SPRING SPACER
7	2	2	D3953-9	GAS SPRING WASHER
8	2	2	D3953-17	GAS SPRING SPACER
9	1	1	D3953-19	GAS SPRING BRACKET
10	1	1	D3953-21	GAS SPRING BRACKET
11	1	1	D3969-3	SPRING
12	1	1	D4017-041	SHORT BASKET BASE ASSY (350)
13	1		D4018-041	SHORT BASKET LID ASSY (350)
14		1	D4019-041	LIGHT LID SHORT BASKET ASSY
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24685-151	COTTER PIN
26	2	2	MS24685-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	2		NAS1149C0432R	WASHER
29	8		NAS1149F0332P	WASHER
30	4		NAS1149F0563P	WASHER



D4032-041 SHORT BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

D4032-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -041: 56 lbs APPROX
-043: 45 lbs APPROX

RELEASED
2010-04-14
MD

C	AN5-21A BOLT WAS AN5-19A BOLT: BOM & (D3-3)	JPH	10.04.06
B	ITEM 15 D4086-232 & 16 D4086-243 REMOVED; ITEM RENUMBERED AS REQD. PLACARDS REMOVED (C6-2); TOP VIEW DETAIL REMOVED (C2-2)	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.08
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D4032	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SHORT BASKET ASSY (350)	NTS
DATE	10.04.06	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

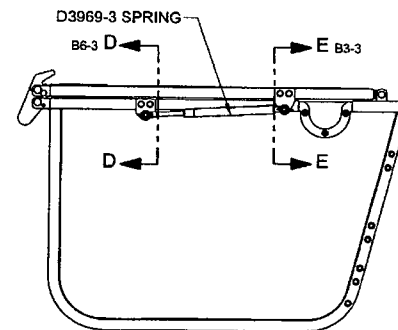
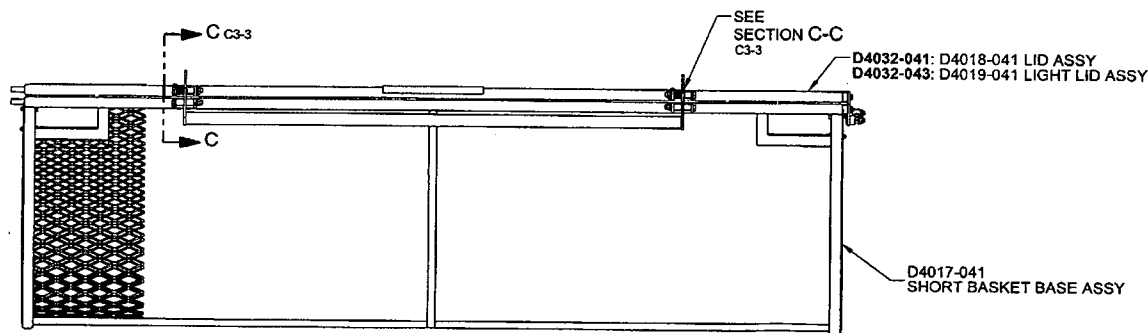
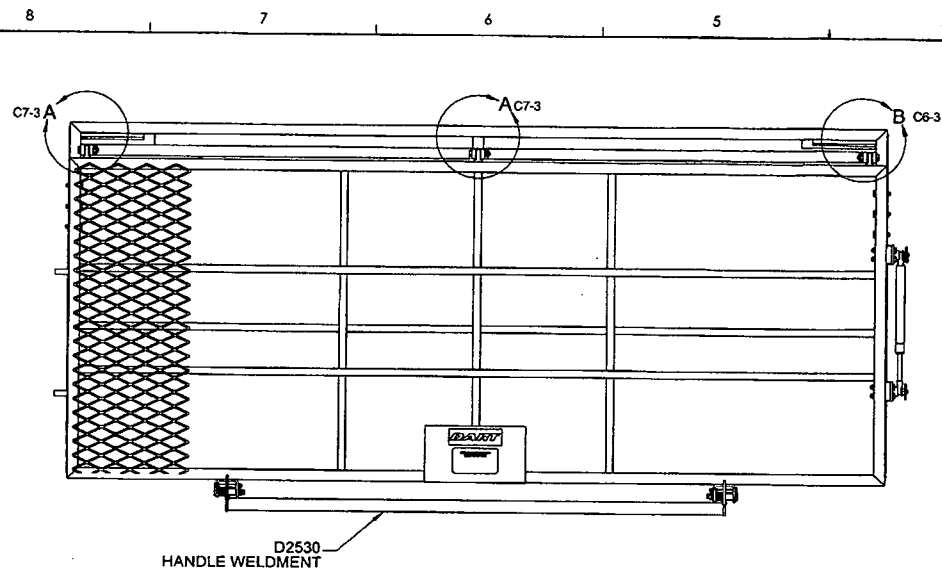
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

59606



D4032-041 SHORT BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

D4032-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2010-04-14
JW

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JP	D4032	SHEET 2 OF 3
APPROVED	JW	TITLE	SCALE
DE APPR.	JW	SHORT BASKET ASSY (350)	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

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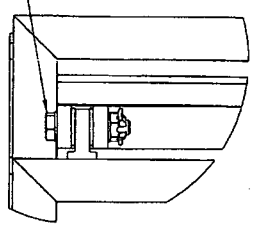
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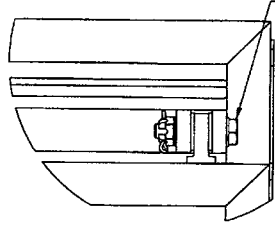
#59605

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



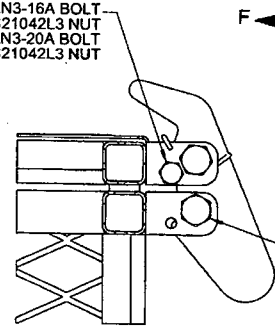
DETAIL A D8-2
D6-2

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



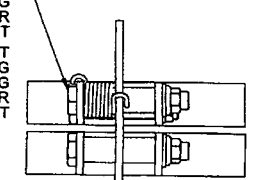
DETAIL B D4-2

D4032-041: AN3-16A BOLT
MS21042L3 NUT
D4032-043: AN3-20A BOLT
MS21042L3 NUT



SECTION C-C B5-2
B7-2

D4032-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT
D4032-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT



VIEW F-F C3-3

AN5-17A BOLT
D2537 BUSHING
NAS1149F0563P WASHER
MS21042L5 NUT

D2530 WELDMENT
REF

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2

D3953-17 GAS SPRING SPACER

D3953-19 GAS SPRING BRACKET

AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-2

RELEASED
2010-04-14

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D4032	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SHORT BASKET ASSY (350)	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries